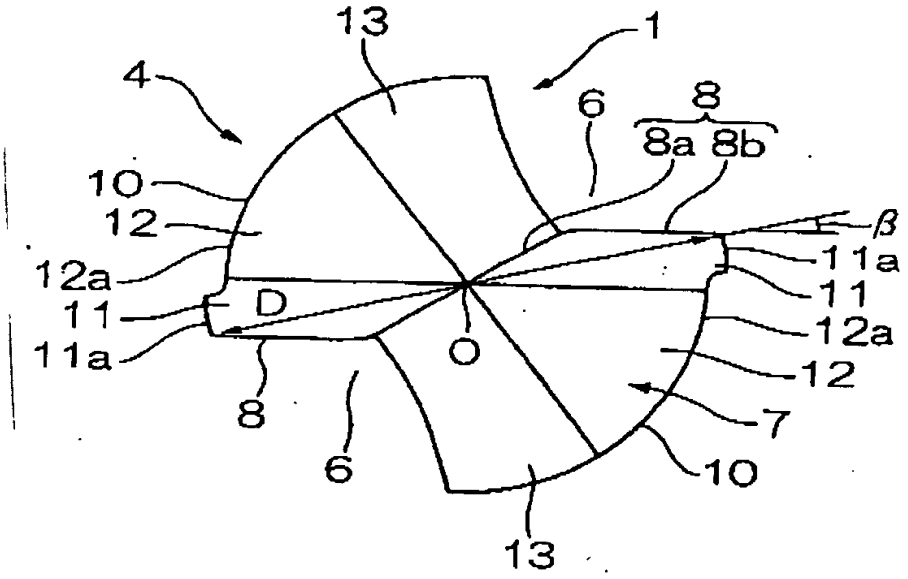

13
1
4
6
8
8a 8b
10
12
β
12a
11a
11
D
11
12a
O
12
8
7
6
10
13

*FIG. 1*

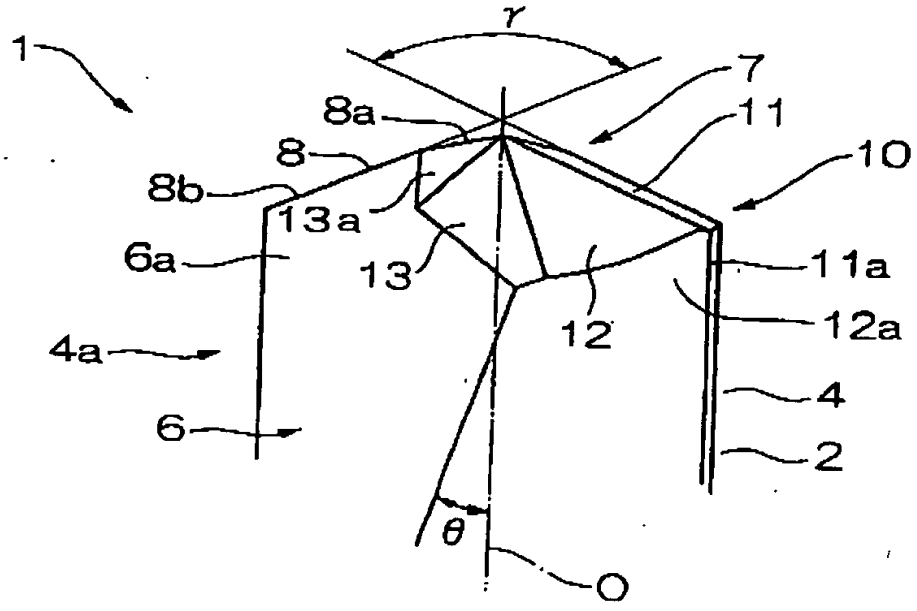
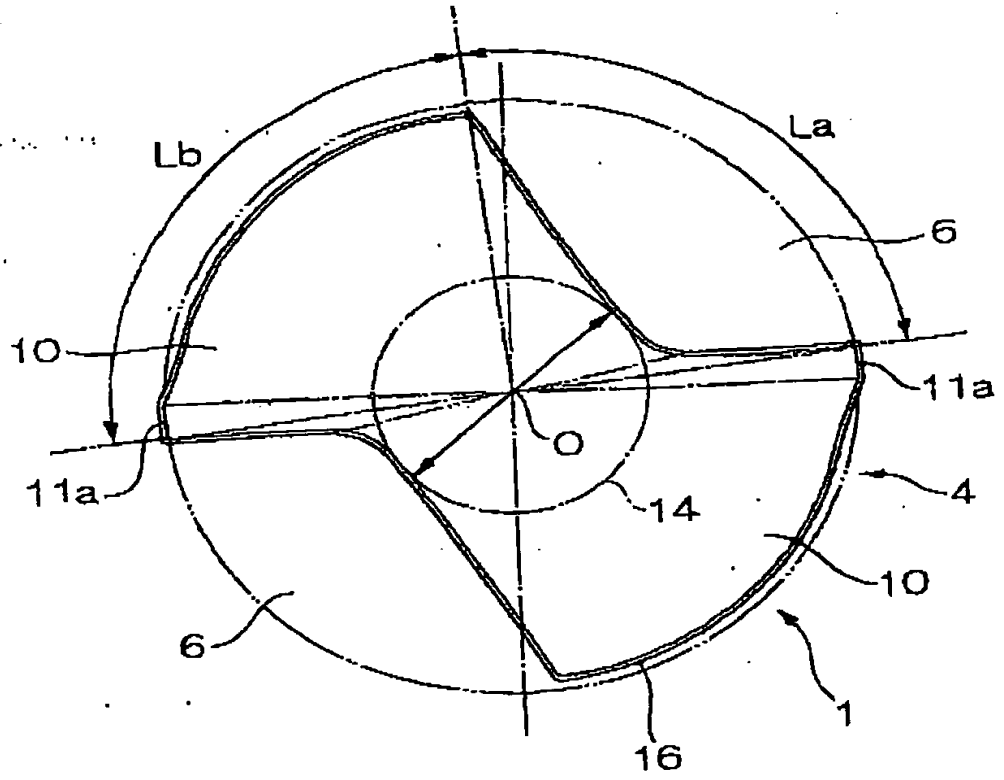

γ
1
7
8a
11
8
10
8b
13a
6a
13
11a
12
12a
4a
4
6
2
θ
O

*FIG.2*

*FIG.3*



EP05720 = 6907286

FIG.4

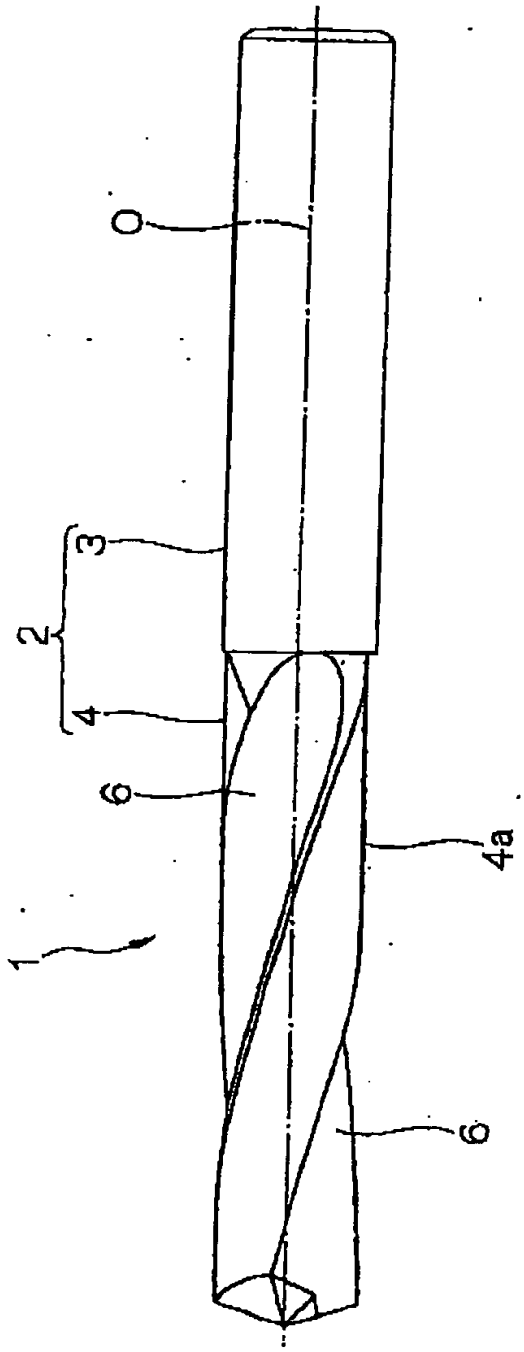


*FIG. 5*

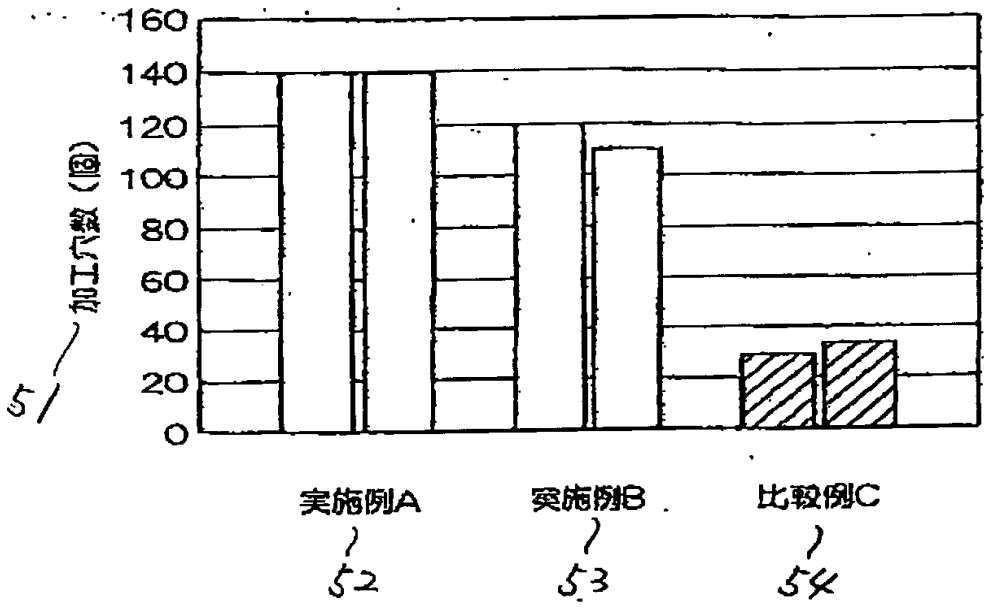
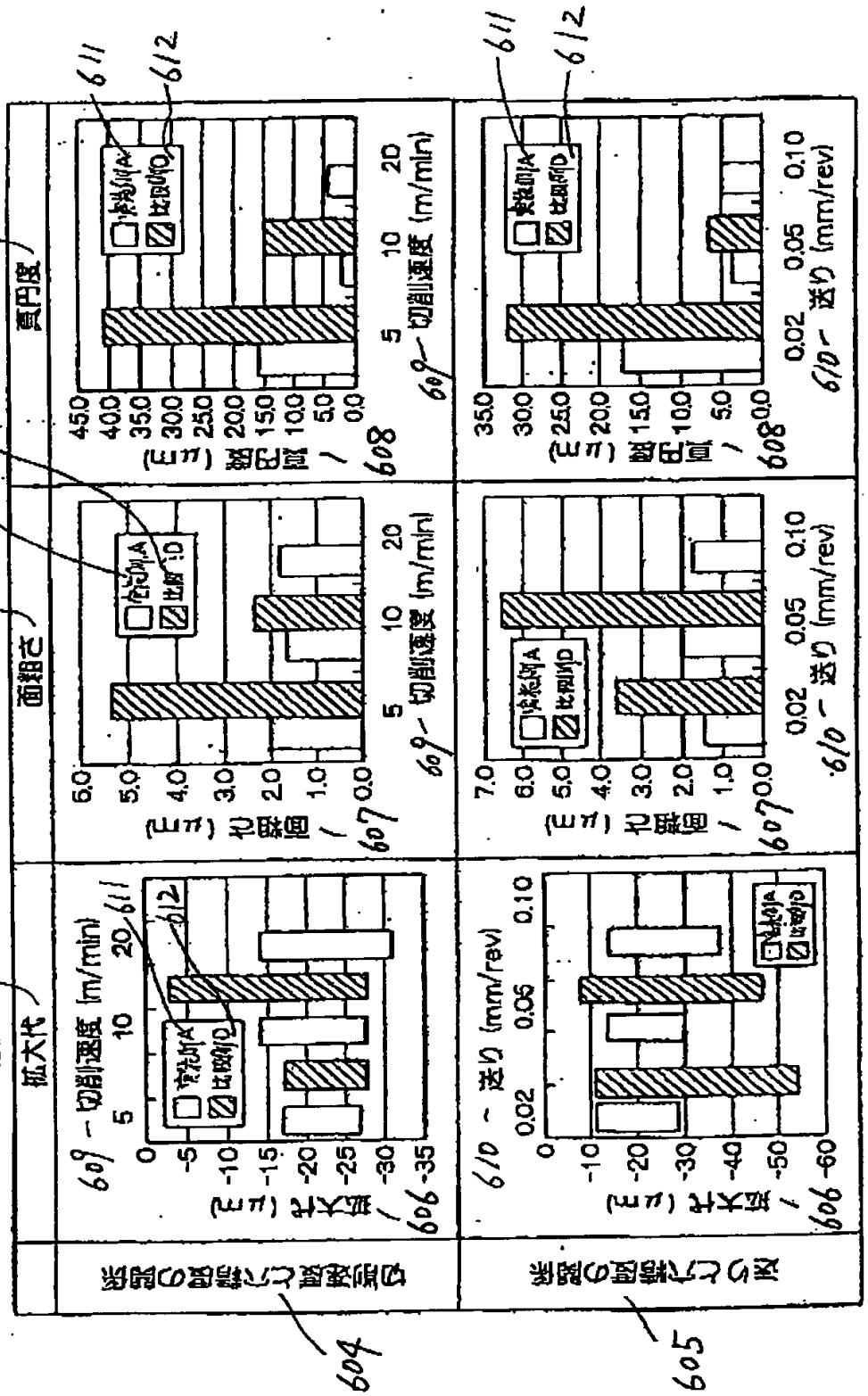


FIG. 6


601
(a) 粗大化
(b) 面粗さ
(c) 真円度
602
603
604
605
606
607
608
609
610
611
612
切削速度と穴精度の関係
送りと穴精度の関係
粗さ (μm)
真円度 (μm)
大きさ (μm)
切削速度 (m/min)
送り (mm/rev)
実施例A
比較例D

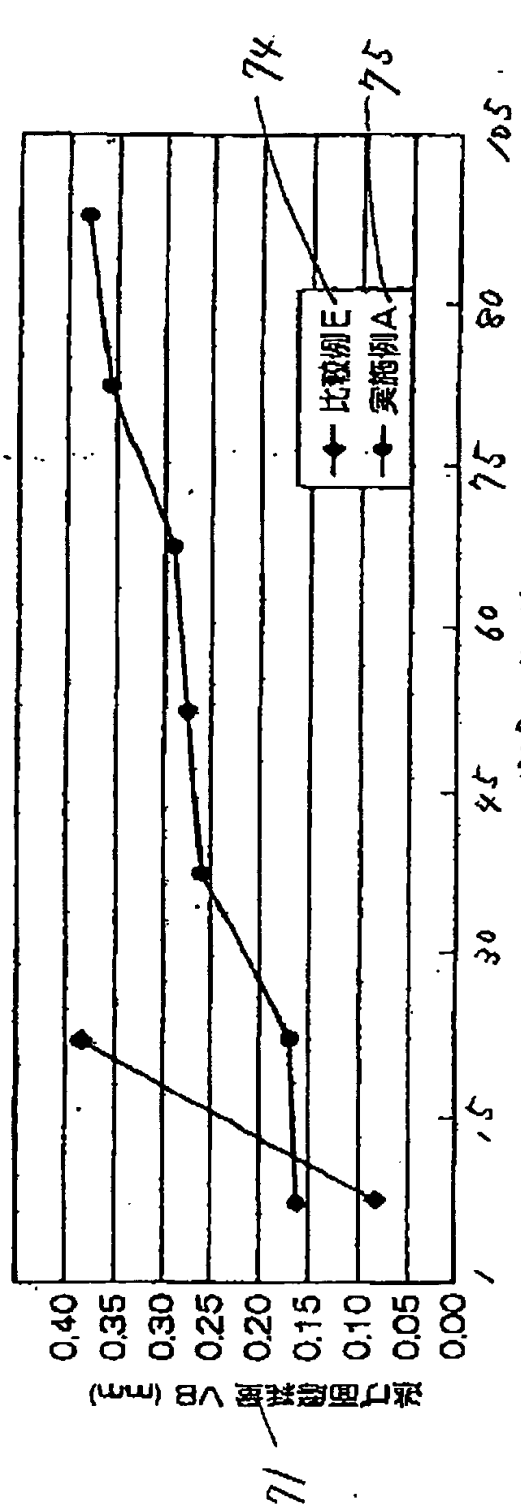

74
75
比較例E
実施例A
0.40
0.35
0.30
0.25
0.20
0.15
0.10
0.05
0.00
1
15
30
45
60
75
80
105
NUMBER OF HOLES
71

FIG. 7A

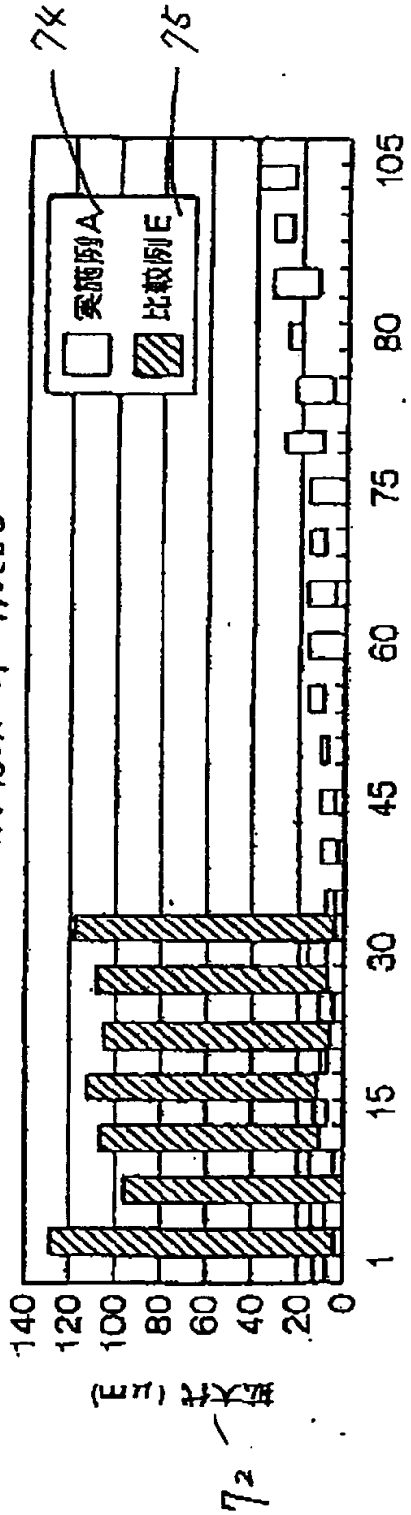

74
75
実施例A
比較例E
140
120
100
80
60
40
20
0
1
15
30
45
60
75
80
105
加工穴数 (穴)
73
72

FIG. 7B